



Dart Aerospace Ltd.
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D3319-1
Job Sheet 210106



Part No: D3319-1

Job Qty: 8 pcs

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/26/20

Job Tracking No:

Due Date: 6/17/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG D3319 REV: E IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev: C Now on Waterjet 06-10-26
JLM IPP REV: D 17.10.25 AS PER DWG REV: D DD VER: JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8		6/16/20	0.17	0.83	Waterjet - Flow		on 26/06/03
		pcs					Waterjet - Omax		
110	QC 2	8		6/16/20	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 26/06/03
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120 QC 8	8 pcs	6/16/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Small Fab - Brake NC - B4B	8 pcs	6/16/20	0.25 0.58	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
160 Automated Welding - B4B	8 pcs	6/16/20	0.00 2.06	Automated Welding - 1 - B4B	
170 QC 10	8 pcs	6/16/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
				QC 10 - 81	
180 QC 5	8 pcs	6/16/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

DAS
JUN 04 2020 40
9-89

JUN 04 2020

20-06-24

				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	PD 20-06-24
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	DAS
190	Spray Paint - 2 - B4B	8 pcs	6/17/20	0.00 1.33	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
200	QC 14	8 pcs	6/17/20	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9
					QC 14 - 68
					QC 14 - 40
					QC 14 - 19
					QC 14 - 43
					QC 14 - 24
					QC 14 - 61
					QC 14 - 81
					QC 14 - 82
					QC 14 - 87
210	Packaging 3-1 - Stock - B4B	8 ✓ pcs	6/17/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B

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				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
220	QC 21 - SA	8 pcs	6/17/20	0.00 0.00	QC 21 - SA - 21 DAS
					QC 21 - SA - 70 21
					QC 21 - SA - 9 9-89
					JUN 26 2020

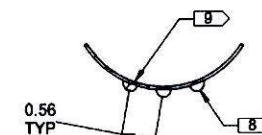
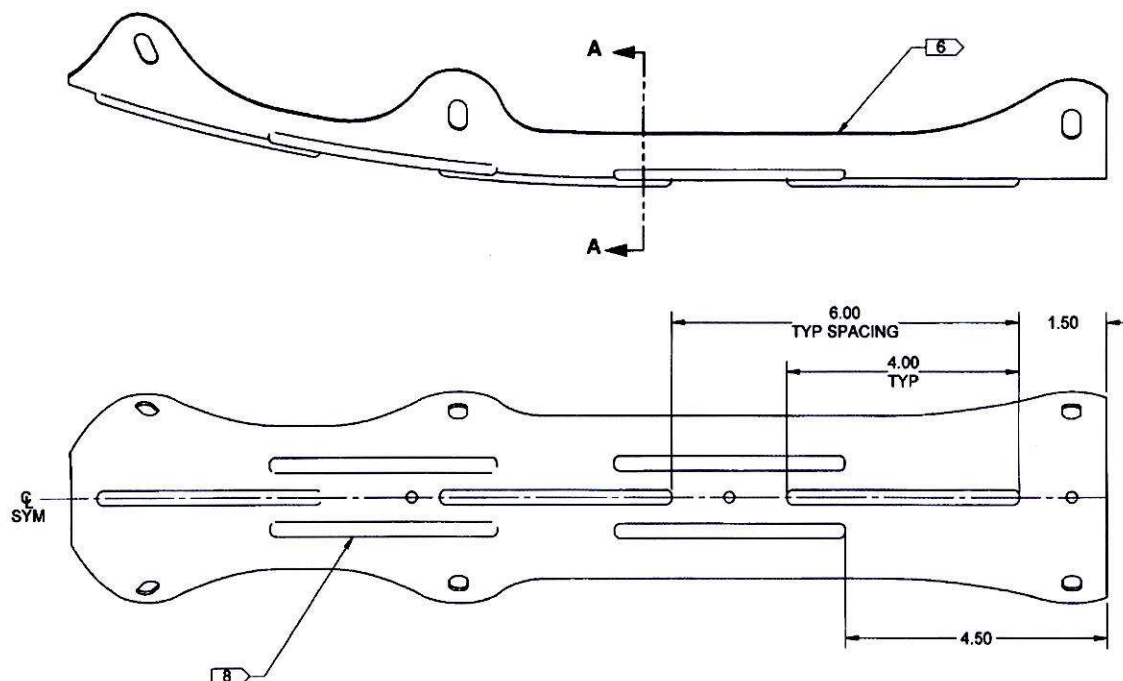
Part Op **100** - 1-Cut as per Dwg D3319 Dwg Rev: E Prog Rev: C 2-Debur if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - QC8- Inspect parts - second check)
140 - (Form as per dwg) 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 2- Form flat on press using DT8776 block
160 - WELD AS PER DWG 8259 HARDCOAT B: M139078
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
190 - Spray Paint / NDT Room) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: 5276824
200 - INSPECT SPRAY PAINT
210 - (Identify as per dwg & Stock Location:) Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location:
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	5.0240 sf (.628 ea)	100-Waterjet - Flow - 1	5243464

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	5	197	0



SECTION A-A

D3319-1 WEARPLATE
MAKE FROM D3319-1BND

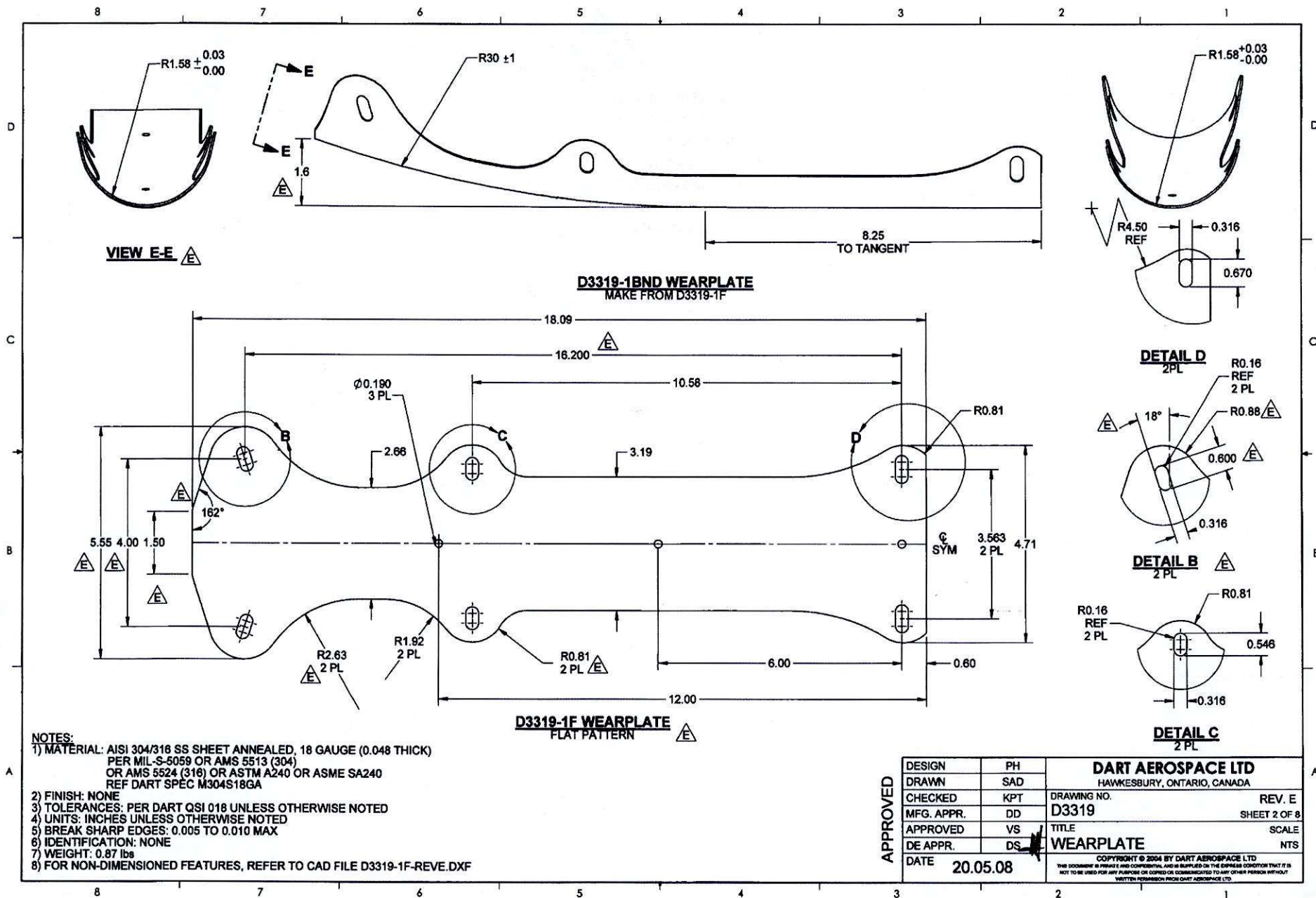
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-1" PER QSI 044 6.1
- 7) WEIGHT: 1.09 lbs
- 8) BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

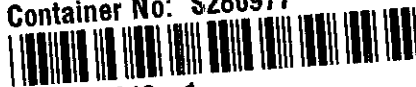
E	MODIFIED D3319-1F FLAT PATTERN TO CORRESPOND TO OEM SKIDTUBE UPDATE, REASON CAR19-342	SAD	20.05.08
D	REVISE DRAWING TO SOLIDWORKS FORMAT, UPDATE NOTES, ADD ROBOTIC WELDING PROCESS, UPDATE TOLERANCES TO REFLECT INSPECTION CAPABILITY, CHANGE DRAIN HOLE LOCATION D3319-1, 12.00 WAS 12.600 (ZN B6-2), CHANGE WELD, PATTERN AND ADD MISSING DRAIN HOLES D3319-1/3, CHANGE MTL TO SS 304/316, ADDED D3319-1BND, SECTION VIEW F-F, AND UPDATED VIEW E-E ADDED DETAIL D, I, P	SAD	17.05.09
C	UPDATE TO CURRENT STANDARDS IAW QSI 043: CLOSED AFTMOST HOLE OF -3/-5/-7 (REF DETAIL G) SEE NCR 12-547	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH OF -3/-5/-7	PH	05.08.08
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	DRAWING NO.	REV. E
MFG. APPR.	DD	D3319	SHEET 1 OF 8
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	20.05.08	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED





Container No: S280977



Part: D3319-1

Job No: 210106

Serial No/Batch: S280977

Revision: REV ~~1~~ E

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/03/20